

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013325**Date Inspected:** 26-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Xian Ping	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	OBG Sub-Assembly	

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Stefan Holmes was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

This QA Inspector observed the following work in progress:

BAY 1:

Flux Cored Arc Welding (FCAW) of 20TR2-025; weld number(s) 011. Welder is identified as 250672. ZPMC Quality Control (QC) is identified as Xiang Feng Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of 20TR1-029; weld number(s) 001 and 007. Welder is identified as 215397. ZPMC Quality Control (QC) is identified as Xiang Feng Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of 20TR2-037; weld number(s) 011. Welder is identified as 059450. ZPMC Quality Control (QC) is identified as Xiang Feng Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of 20TR1-040; weld number(s) 003. Welder is identified as 216872. ZPMC

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Quality Control (QC) is identified as Xiang Feng Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of 20TR1-037; weld number(s) 011. Welder is identified as 216872. ZPMC Quality Control (QC) is identified as Xiang Feng Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2231-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

BAY 5:

Flux Cored Arc Welding (FCAW) pursuant to Critical Weld Repair (CWR) B-CWR1102 (for Buttering) of 11TR4-001. Welder is identified as 203710. ZPMC Quality Control (QC) is identified as Xiang Feng Feng. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-1G(1F)-Repair-1. Welding appears to conform to the requirements of the WPS and CWR used.

Flux Cored Arc Welding (FCAW) pursuant to Critical Weld Repair (CWR) B-CWR1102 (for Buttering) of 10TR3-027. Welder is identified as 215083. ZPMC Quality Control (QC) is identified as Xiang Feng Feng. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-1G(1F)-Repair-1. Welding appears to conform to the requirements of the WPS and CWR used.

Flux Cored Arc Welding (FCAW) pursuant to Critical Weld Repair (CWR) B-CWR1102 (for Buttering) of 11TR3-026. Welder is identified as 222387. ZPMC Quality Control (QC) is identified as Xiang Feng Feng. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-1G(1F)-Repair-1. Welding appears to conform to the requirements of the WPS and CWR used.

Flux Cored Arc Welding (FCAW) pursuant to Weld Repair Report (WRR) B-WRR10993 (for UT Reject) of 10TR2-018; weld number(s) 014. Welder is identified as 204342 and 222387. ZPMC Quality Control (QC) is identified as Xiang Feng Feng. Weld Procedure Specification (WPS) is identified as WPS-345-FCAW-1G(1F)-Repair-1. Welding appears to conform to the requirements of the WPS and CWR used.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Holmes,Stefan	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
